

Date: Tuesday, 16/12/2008 2:13:17 PM
 User: Julie Dawson

Split

Process Sheet

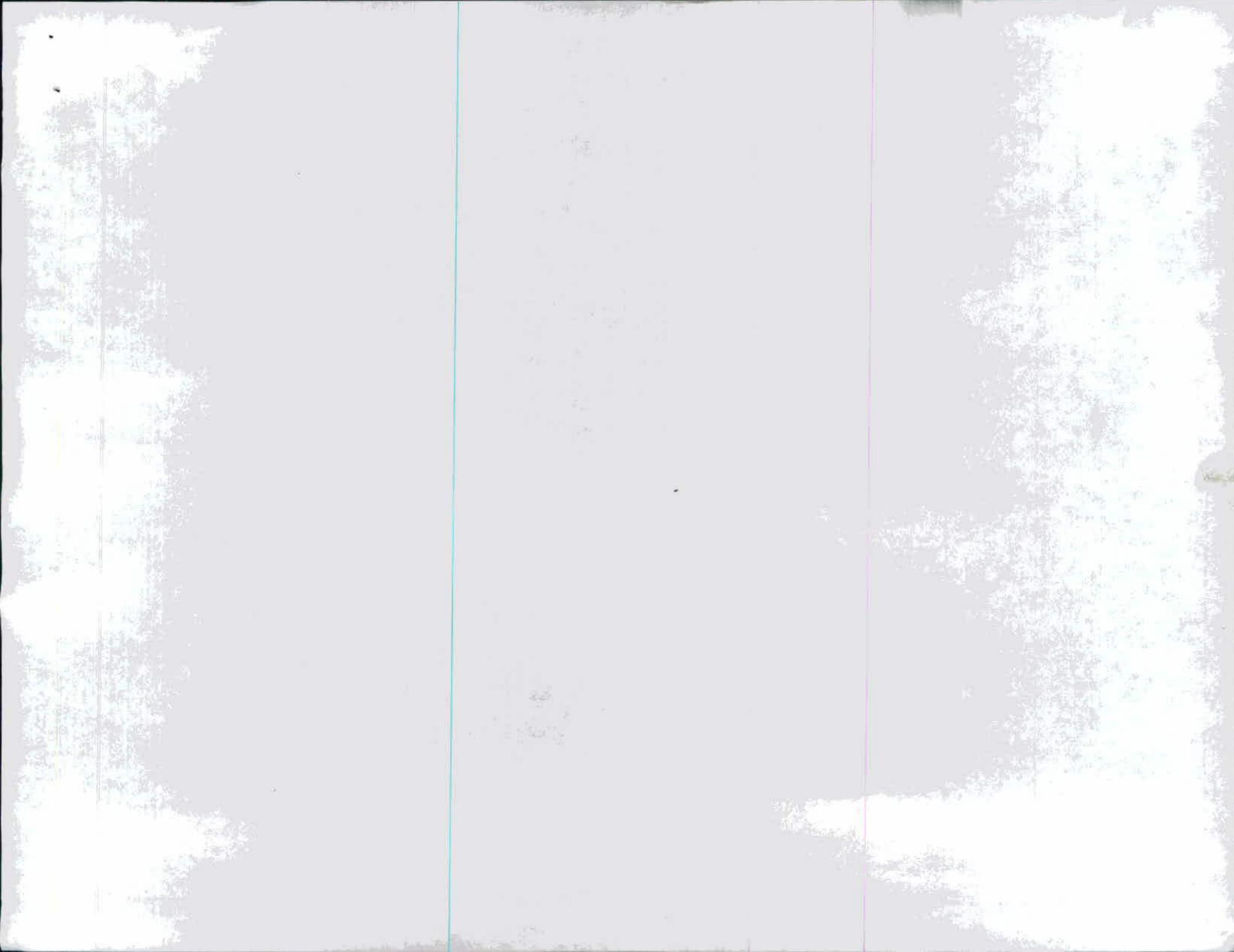
| | | | | | | | |
|-----------------------|--|----------|------------------|------------------|-------------------|--|----------|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : BAFFLE ASSEMBLY | | |
| Job Number | : 44125 | | | Part Number | : D3276042 | | |
| Estimate Number | : 11265 | | | Drawing Number | : D3276 REV B | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 16/12/2008 | S.O. No. | : | Drawing Revision | : B | | |
| Prsh Rev. | : NC | | | Material | : | | |
| First Issue | : / / | Type | : SMALL /MED FAB | Due Date | : 30/12/2008 | | |
| Previous Run | : 36597 | | | Qty: | 10 | | Um: Each |
| Written By | : | | | | | | |
| Checked & Approved By | : JLD 8-12-16 | | | | | | |
| Comment | : Est Rev:A New Issue 05-12-06 JLM Est Rev:B Now on Waterjet 06-09-06 JLM | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|--|
| 1.0 | M6061T6S040 | 6061-T6 .040 Sheet |
| | | |
| Comment: Qty.: 1.0715 sf(s)/Unit Total : 10.7153 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.040" thick (M6061T6S.040) Batch: 109396 1B 8-12-17 | | |
| 2.0 | WATER JET | FLOW WATER JET |
| | | |
| Comment: FLOW WATER JET 1-Cut as per Dwg D3276 Dwg Rev: B 1B 8-12-17 Prog Rev: B | | |
| 2-Deburr if necessary 1B 8-12-17 | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE 1B 8-12-17 | | |
| 4.0 | QC8 | SECOND CHECK |
| | | |
| Comment: SECOND CHECK S 08/12/17 (+2) | | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
| | | |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr | | |



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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 44125

Part Number: D3276042

Job Number:



Seq. #: Machine Or Operation: Description: SB08/12/18 ①
2-Roll as per Dwg D3276

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276

SB08/12/18

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



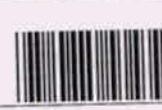
SB08/12/18 ①

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



SB08/12/18 ①

9.0 POWDER COATING POWDER COATING



M109996



SB08/12/18 ①

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9:50
OF

START TIME:

320 OF

OVEN TEMPERATURE:

10:20

FINISH TIME:

10:20

m-f 08/12/18

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



m-f 08/12/18 ①

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 08/12/18

11.0 D2464 3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total : 22.5000 f(s)

Pick:

Qty Part Number Description Batch
27.0" D2464 Neoprene Seal 639469

SB08/12/18

12.0 D32763 Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D3276-3 Decal B36633

SB08/12/18



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 44125

Part Number: D3276042

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D3276

08/12/18 e

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/18 p

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PPP-44115*

08/12/18 (x)

16.0 QC21 FINAL INSPECTION/W/O RELEASE



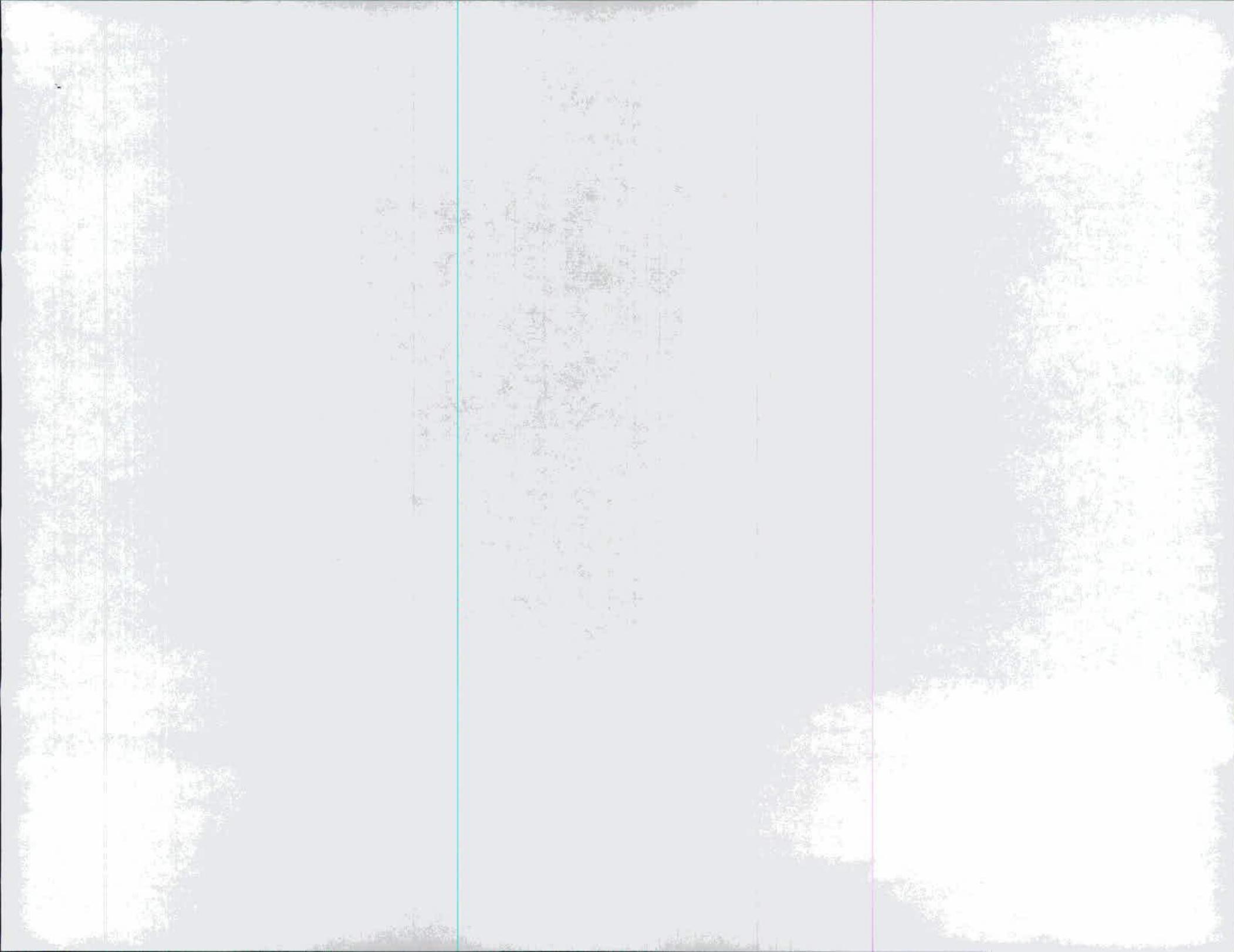
Comment: FINAL INSPECTION/W/O RELEASE

08/12/19 J

Job Completion



08/12/18



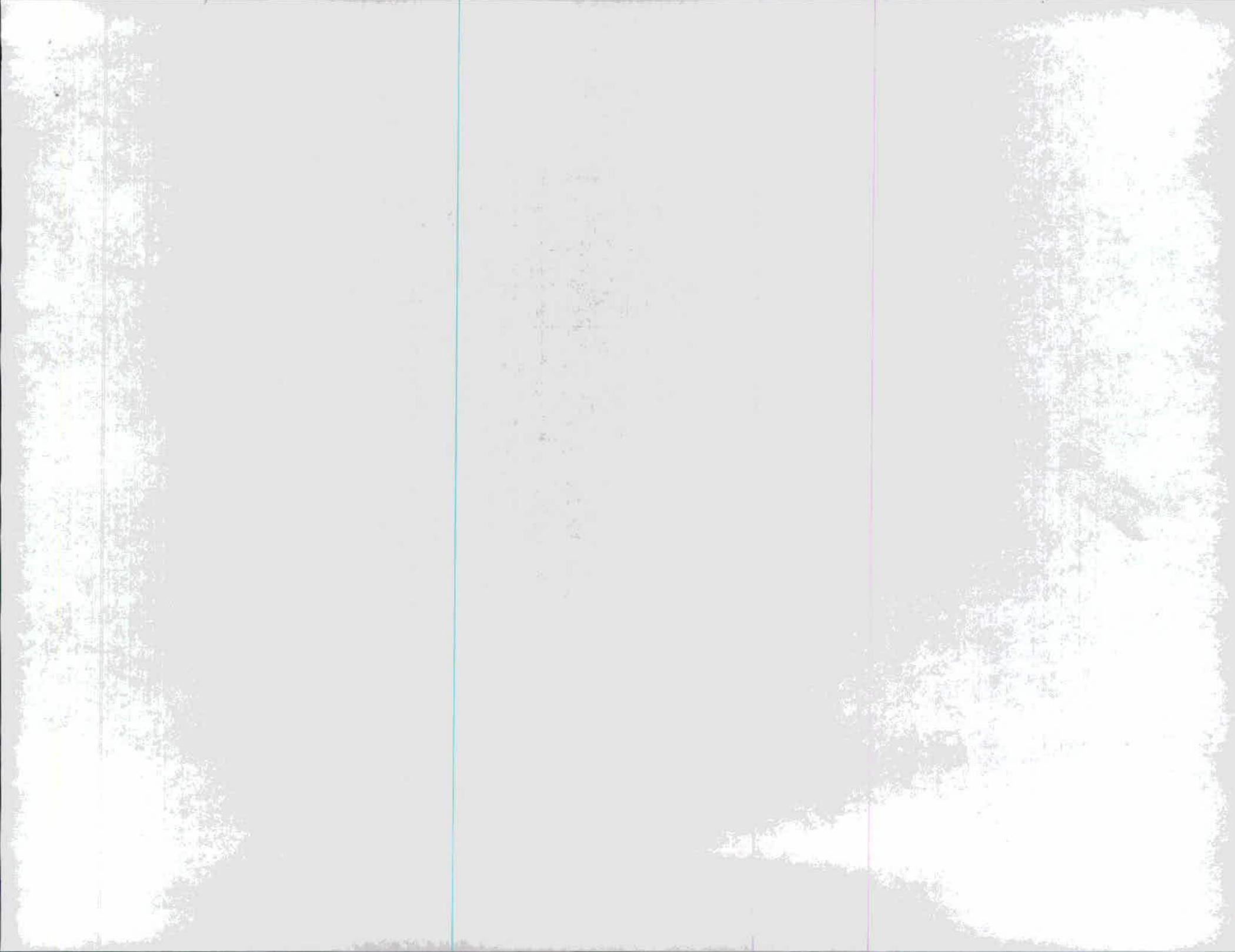
| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 44125 |
| Description: Baffle | Part Number: | D3276-1 |
| Inspection Dwg: D3276 | Rev: B | Page 1 of 1 |

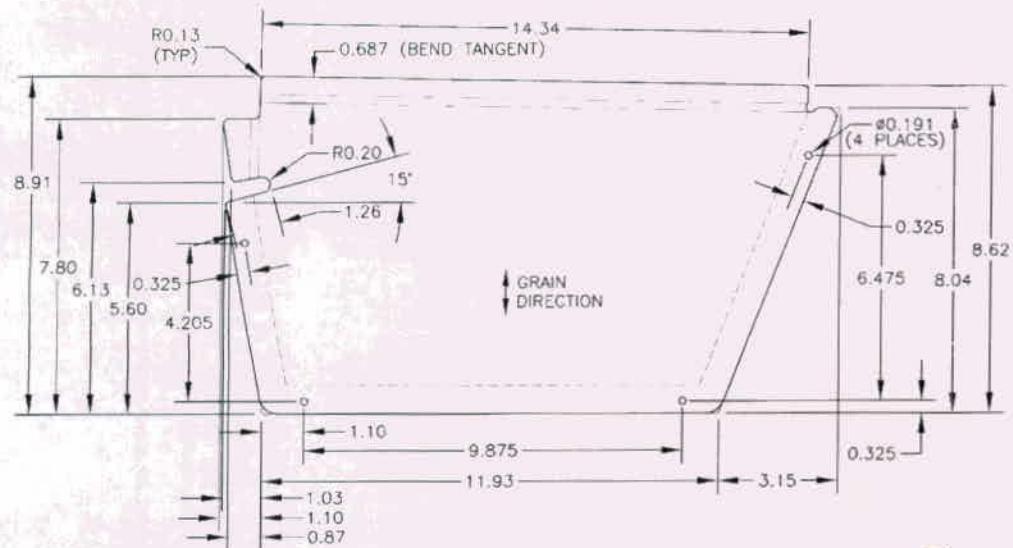
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|---------|-------------|----------|---------------------|-----|
| Measured by: | RB | Audited by: | J | Prototype Approval: | N/A |
| Date: | 8-12-17 | Date: | 08/12/17 | Date: | N/A |

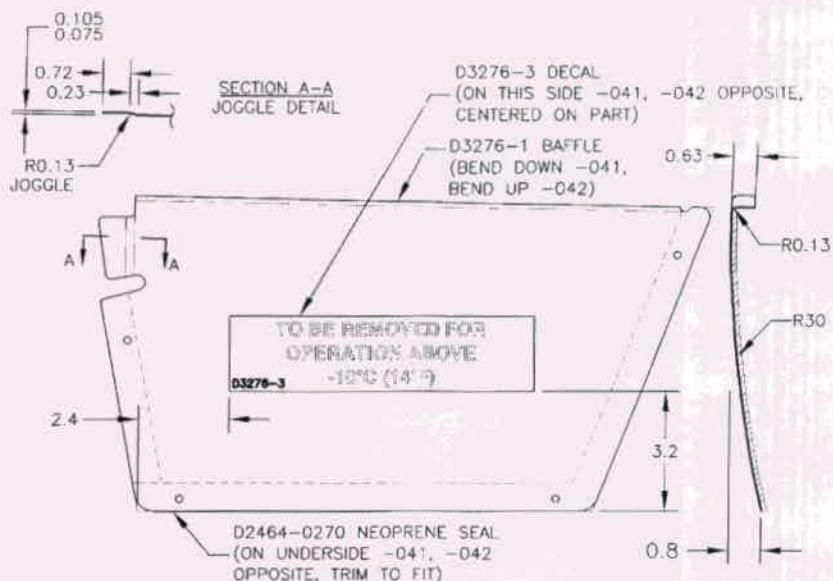
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------------|--|
| A | 05.04.26 | New Issue | P/O D044-717-011 | KJ/JLM   |





D3276-1 BAFFLE (FLAT PATTERN)

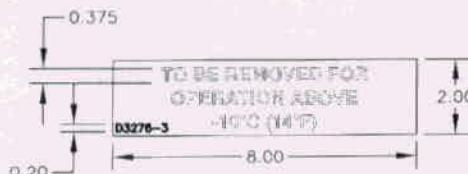
- 1) MACHINE PER DWG FILE "D3276-A.DWG"
 - 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)
(REF DART SPEC. M6061T6S.040)
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



3276-041 BAFFLE ASSEMBLY, LH (SHOWN)

D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

REFERENCE ONLY



D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
 - 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | |
|----------|-----------------|--|
| A | 05.01.07 | NEW ISSUE |
| DESIGN | DRAWN BY | DART |
| CP | CP | DART AEROSPACE LTD. MANNESBURG, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. |
| | | 03276 |
| DATE | TITLE | REV. B SHEET 1 OF 1 SCALE |
| 05.01.25 | BAFFLE ASSEMBLY | 1:5 |

obenbekämpft